

Date: Monday, 02/02/2009 11:50:02 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	CONSOLE SIDE H (206 HI-SLOPE)
<b>Job Number</b> :	45391		
<b>Estimate Number</b> :	11001		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2602 <b>D2601-2</b>
<b>This Issue</b> :	02/02/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2602 REV B
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	44392	<b>Drawing Revision</b> :	B
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JLD 09.02.02</u>	<b>Due Date</b> :	12/02/2009
<b>Comment</b> :	Est. E 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-1 Est Rev:E Now On Waterjet 07-03-22 JLM Est Rev:F RevB as per dwg ECN1059 DD verified by:EC		

Qty: 4 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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**Comment:** Qty.: 1.4146 sf(s)/Unit Total : 5.6582 sf(s)  
 2024-T3 .040 sheet  
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
 (M2024T3S.040) Batch 110337 **B 9-2-12**

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D2602  
 \*\*\*\*\*Same Cutting File for -1 & -2 \*\*\*\*\*  
 Dwg Rev: B  
 Prog Rev: B **B 9-2-12**  
 2-Deburr if necessary **B 9-2-12**

7

PTC

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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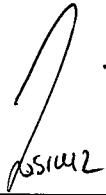
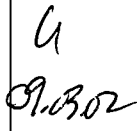
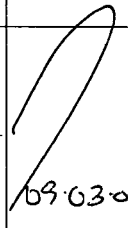
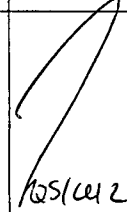
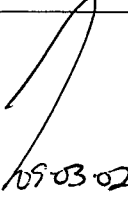
**Comment:** SECOND CHECK

80210364 **(47)**

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2601-2 PAR #: N/A Fault Category: Prod/Eng Coord. NCR NCR: Yes No Q DQA: D Date: 09/03/12  
 Resolution: DOC. REVISED Disposition: re-worked QA: N/C Closed: D Date: 09/03/12

NCR: <u>45391</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-03-02	2.0	In correct parts made. D2602 as D2601. Employee worked off of the dwg, and the incorrect dwg was attached. Affected w/o's: 45390, 44391, 45391, & 44392		See NCR 09-027 update w/o to a D2601	 09.03.02	 09-03-02	 09/03/12	 09-03-02

NOTE: Date & initial all entries

Date: Monday, 02/02/2009 11:50:02 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE (206 HI-SLOPE)

Job Number: 45391

Part Number: D26022 *D2601.2*

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D2602

*SB 02/03/04*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 02/03/06 (+7-2)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*UMD/BR.*

*(X7) 09/03/09*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*a.m. 09.03.06 (7)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*9/3/10*

*(TK) SP*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/03/10*

Job Completion



*MF 09-03-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	45391
<b>Description:</b> CONSOLE SIDE		<b>Part Number:</b>	D2601-2
<b>Inspection Dwg:</b> D2601-2 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101	X			
13.00	+/- .030	12.981	X			
1.35	+/- .030	1.352	X			
1.375	+/- .010	1.372	X			
.300	+/- .010	.301	X			
6.000	+/- .010	5.994	X			
9.45	+/- .030	9.45	X			
10.90	+/- .030	10.90	X			
8.875	+/- .010	8.878	X			
.340	+/- .010	.338	X			
.500	+/- .010	.500	X			
.875	+/- .010	.880	X			
1.254	+/- .010	1.247	X			
2.47	+/- .030	2.483	X			
.92	+/- .030	.911	X			
11.239	+/- .010	11.221	X			
10.70	+/- .030	10.694	X			
13.75	+/- .030	13.75	X			
14.18	+/- .030	14.18	X			
.838	+/- .010	.838	X			
2.648	+/- .010	2.650	X			
.040	+/- .010	.046	X			

<b>Measured by:</b>	IB	<b>Audited by:</b>	[Signature]	<b>Prototype Approval:</b>	N
<b>Date:</b>	9-3-3	<b>Date:</b>	09/03/04	<b>Date:</b>	19

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

